



Dart Aerospace Ltd.
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Tel (613) 632-5200

D4417-041
Job Sheet 177995



Part No: D4417-041

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/24/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 3,4 IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP REV:B 11.08.17 PER REV.B. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Large Fab-4		DC 2018-05-25
100	Large Fab	1 pcs	6/29/18	6/29/18	0.00	1.76	Large Fab 8		DC 2018-05-25
120	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		CPC
130	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.36	HandFinish1		BEB 18-05-29
140	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC7-3		BE
150	Large Fab	1 pcs	6/29/18	6/29/18	0.00	1.76	Large Fab 2		14 CPC
160	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC10		10 13-06-12
170	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		10 13-06-12
180	Powdercoat	1 pcs	6/29/18	6/29/18	0.00	0.26	Powdercoat1		BE 18-6-13
190	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.36	HandFinish3		11 13-6-13
200	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC3		11 13-6-13
210	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		11 13-6-13
220	QC21-SA	1 Ea	6/29/18	6/29/18	0.00	0.00	QC21		21 18-06-13

Part Op 100 - 1-Cut D2622 to 106"AS PER DWG 2-DRILL HOLES USING DT9765 3-CUT ENDS AT 45 DEG AS PER DWG
Descriptions: 150 - 1-SWAGE TUBES AS PER DWG 2-Weld cap per dwg D4417 3-grind flush

180 - 1-Touch up alodine

220 - 4- OPEN HOLES AT 0.508" AS PER DWG

M138839 START: 8:15 CUT: 320° FINISH: 8:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	SCM 11/6
D2734	Step End Plate	2 Ea (2 ea)	150-Large Fab	SD 63695
D4425-1	Step Spacer	2 Ea (2 ea)	150-Large Fab	3140054

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	123	0
150-Large Fab	D2734	2	32	0
	D4425-1	2	8	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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Date: 05/25/18

DART
AEROSPACE

Container No: S074376
Part: D4417 - 041
Job No: 177995
Serial No/Batch: S074376
Revision:
Inspector:

FAULT CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence